



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2896-1
Job Sheet 173688



Part No: D2896-1

Job Qty: 10 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 02.11.26 Reformat; Added P/O; Added mask hole KJ IPP Rev:C As per Rev B 07-04-16
JLM IPP D 08.03.19 Re-format EC verified by DD IPP REV:E 11.10.03 ASPER REV:C DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		3/28/18	0.00	0.00	Start Up Machining-1		
100	CNC Vertical Machining	10 pcs		3/30/18	0.32	33.11	HAAS1-2		
120	QC	10 pcs		3/30/18	0.00	0.00	QC8		
130	Packaging	10 pcs		3/30/18	0.00	0.00	Packaging3-1		
140	QC21-SA	10 Ea		3/30/18	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FA167 Folio Rev: _____ Deburr ****Program Batch #*****
Descriptions: 130 - LOCATION : ~~LG053~~

21
9-80

APR 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK080	D2896-1 Turning Detail	5 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK080	5	5	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	2.152Inches + 0.020 - 0.000	2.172 2.152		
2	Support	2.340Inches + 0.020 - 0.000	2.360 2.340		
3	Support	3.550Inches + 0.010 - 0.000	3.560 3.550		
4	Support	3.770Inches + 0.020 - 0.000	3.790 3.770		
5	Support	0.065Inches + 0.020 - 0.000	0.085 0.065		
6	Support	0.315Inches + 0.020 - 0.000	0.335 0.315		
7	Support	1.420Inches + 0.060 - 0.000	1.480 1.420		



Container No: S053883



Part: D2896-1

Job No: 173688

Serial No/Batch: S053883

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkebury, ON K0A 1K7
CANADA
TEL.: 1 513 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/22/18

8	Support	0.833Inches	+ 0.020 - 0.000	0.853 0.833
9	Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240
10	Support	0.261Inches	+ 0.005 - 0.000	0.266 0.261
11	Support	0.189Inches	+ 0.005 - 0.000	0.194 0.189
12	Support	1.970Inches	+ 0.060 - 0.000	2.030 1.970
13	Support	0.625Inches	+ 0.005 - 0.000	0.630 0.625
14	Support	101.750Inches	+ 4.000 - 0.000	105.750 101.750
15	Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053
16	Support	0.926Inches	+ 0.020 - 0.000	0.946 0.926

Plex 3/6/18 12:55 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.152	2.172		2.162	2.162	2.160	2.161	2.161
AB	2.340	2.360		2.350	2.350	2.352	2.350	2.349
AC	3.550	3.560		3.552	3.553	3.559	3.560	3.555
AD	3.770	3.790		3.780	3.780	3.784	3.784	3.783
AE	0.065 x 0.315	0.085 x 0.335		0.069 x 0.322	0.070 x 0.320	0.069 x 0.318	0.068 x 0.315	0.068 x 0.315
AF	1.42	1.48		1.445	1.445	1.448	1.446	1.445
AG	0.833	0.853		.843	.845	.839	.842	.843
AH	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AI	0.261	0.266		.261Ø	.261Ø	.261Ø	.261Ø	.261Ø
AJ	0.189	0.194		.189Ø	.189Ø	.189Ø	.189Ø	.189Ø
AK	1.970	2.030		1.994	1.994	2.000	2.000	2.002
AL	0.625	0.630		.626Ø	.626Ø	.626Ø	.626Ø	.626Ø
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		R.063	R.063	R.063	R.063	R.063
AO	0.926	0.946		.938	.937	.934	.936	.938
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				.001	0.000	.001	.001	.001

Measured by:	<i>mu. / on</i>	Date:	2018/03/22
Audited by:	<i>mm</i>	Date:	18 / 04 / 08
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Support		Part Number:	D2896-1
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FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.152	2.172		2.160	2.162	2.163	2.165	2.163
AB	2.340	2.360		2.353	2.354	2.355	2.353	2.358
AC	3.550	3.560		3.554	3.554	3.551	3.552	3.555
AD	3.770	3.790		3.745	3.772	3.740	3.780	3.780
AE	0.065 x 0.315	0.085 x 0.335		0.064x315	0.075x335	0.074x335	0.072x325	0.075x335
AF	1.42	1.48		1.449	1.455	1.455	1.448	1.453
AG	0.833	0.853		0.845	0.844	0.842	0.842	0.842
AH	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AI	0.261	0.266		0.2610	0.2610	0.2610	0.2610	0.2610
AJ	0.189	0.194		0.1890	0.1890	0.1890	0.1890	0.1890
AK	1.970	2.030		1.997	1.999	2.004	2.005	2.001
AL	0.625	0.630		0.6260	0.6260	0.6260	0.6260	0.6260
AM	101.75	105.75		103.75	103.70	103.50	102.90	103.75
AN	0.053	0.073		R.063	R.063	R.063	R.063	R.063
AO	0.926	0.946		0.940	0.943	0.945	0.940	0.937
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				001	001	002	0000	

Measured by:	<i>MM</i>	Date:	2018/03/23
Audited by:	<i>mm</i>	Date:	18/04/08
Preliminary Approval:		Date:	

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